Work Order ID 102592

102592

June-04-13 10:24:54 AM

Item ID: D206-817-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Start Qty:** 5.00 *5*

Required Date: 6/21/13 **Req'd Qty:** 5.00 *5*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-06-04 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
IIN-D206-817	D	JB							
100	DOCUMENT CONTROL	0.00							
100						5			
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-817-011 CHG003								
110	Pick Kit	0.00							
110						5			13-06-26 JB
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120						5			
QC	**Memo**	0.00							
Quality Control									

13/8/15 DAS 0683 004 per ECN13-583

13/8/15 DAS 0683

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 102592

102592

June-04-13 10:24:54 AM

Item ID: D206-817-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Screw-In Windshield, LH/RH **Stop** *NS2*

Start Date: 6/04/13 **Start Qty:** 5.00 *5*

Required Date: 6/21/13 **Req'd Qty:** 5.00 *5*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging									
Packaging	**Memo**	0.00							
	Identify and pack for shipping as per PPP D206-817-011 Location: OSI								
	PPP Rev: _____ (TA)								
	EXPIRY DATE OF D4595 14-04-23 (x3) 01-14-2014								
	***INDICATE ON BOX EXPIRY DATE OF TAPE ***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control	ENTER EXPIRY DATE IN LOT MAINTENANCE FOR TAPE								

13/8/15 SD 8

MCJ 13-08-20

MF
13-8-18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-04-13 10:24:59 AM

9

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

Comments: IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B 12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12 ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN dwg rev.D DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-3 *D4541-3* Bracket		Manufactured	No			110	Each	1.0000	1 **	5			

M.D. 13-07-24

Location	Loc Qty	Loc Code
st530	1	B101301
91421	1	

D4541-4 *D4541-4* Bracket		Manufactured	No			110	Each	5.0000	1 **	5			

3X102596 M.D.

Location	Loc Qty	Loc Code
st530	5	B101617 (2x)
101302	5	

D4541-5 *D4541-5* Bracket		Manufactured	No			110	Each	49.0000	1 **	5			

M.D.

Location	Loc Qty	Loc Code
ST525	49	B101305
100796	15	
101304	10	
101305	20	
91425	4	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

D4541-6 Manufactured No 110 Each 52.0000

D4541-6

Bracket

Location	Loc Qty	Loc Code
ST525	52	
100606	12	
100832	10	
101307	15	
101308	15	

D4541-7 Manufactured No 110 Each 3.0000

D4541-7

Bracket

Location	Loc Qty	Loc Code
ST525	3	
101309	3	

D4541-8 Manufactured No 110 Each 15.0000

D4541-8

Bracket

Location	Loc Qty	Loc Code
st527A	12	
101311	12	
st529	3	
101312	3	

D4542-3 Manufactured No 110 Each 20.0000

D4542-3

Retainer, Inner

Location	Loc Qty	Loc Code
ST527	12	
100604	12	
st529	8	
101317	8	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric.
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

D4542-5	Manufactured	No	110	Each	10.0000	2 (10)

D4542-5

Retainer, Inner

Location	Loc Qty	Loc Code
ST525	10	
101319	10	

B103186 (9x) B102604 (1x)

D4542-7	Manufactured	No	110	Each	31.0000	2 (10)

D4542-7

Retainer, Inner

Location	Loc Qty	Loc Code
ST525	31	
101185	1	
101321	30	

B102605

D4543-1	Manufactured	No	110	Each	0.0000	1 (5)

D4543-1

Retainer, Outer, LH

B103380

D4543-2	Manufactured	No	110	Each	15.0000	1 (5)

D4543-2

Retainer, Outer, RH

Location	Loc Qty	Loc Code
st529	15	
101325	15	

B103381 (2x) B102607 (3x)

D4543-3	Manufactured	No	110	Each	1.0000	1 (5)

D4543-3

Retainer, Outer, LH

Location	Loc Qty	Loc Code
ST528	1	
100598	1	

~~B101330 (3x)~~ ~~B100773 (2x)~~ B101328

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

D4543-4 *D4543-4* Retainer, Outer, RH	Manufactured	No	110	Each	2.0000	1

Location	Loc Qty	Loc Code
st529	2	
101329	2	

D4543-5 *D4543-5* Retainer, Outer, LH	Manufactured	No	110	Each	0.0000	1
D4543-6 *D4543-6* Retainer, Outer, RH	Manufactured	No	110	Each	0.0000	5
D4544-1 *D4544-1* Retainer, Center	Manufactured	No	110	Each	36.0000	1

Location	Loc Qty	Loc Code
st530	36	
100909	16	
101335	10	
101336	10	

D4545-041 *D4545-041* Retainer, Inner, LH (Black)	Manufactured	No	110	Each	2.0000	1

Location	Loc Qty	Loc Code
ST531	2	
91495	2	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

D4545-042 *D4545-042* Retainer, Inner, RH (Low)	Manufactured	No	110	Each	1.0000	**

Location	Loc Qty	Loc Code
ST531	1	
91502	1	

D4594-1 *D4594-1* Plate	Manufactured	No	110	Each	27.0000	**

Location	Loc Qty	Loc Code
ST176	3	
91527	3	
ST525	24	
101342	12	
101343	12	

D4595-150-25 *D4595-150-25* Sealant Tape	Manufactured	No	110	Each	11.0000	**

Location	Loc Qty	Loc Code
ST416	11	
97209	3	
91533	8	

per ECN B-583

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function

☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence

☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge

☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

AN525-10R7	Purchased	No	110	Each	5,430.000	475

AN525-10R7

Screw

**

13-06-26

Location		Loc Qty	Loc Code	
ST344		30		
	115371	14		
	120833	2		
	123248	2		
	123355	1		
	123522	2		
	123603	9		
ST506		1115		
	124307	2		
	124561	1113		
st507		1500		
	124093	1500		
ST509		1500		
	125268	1500		
ST517a		1285		
	124555	1285		124555

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592 *102592*

Parent Item: D206-817-011 *D206-817-011*

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

MS20426AD3-4	Purchased	No		110	Each	24.644.00	112

MS20426AD3-4

RIVET

Location	Loc Qty	Loc Code
ST333	12	
123352	12	
ST334	8000	
123164	8000	
ST505	8000	123164
124814	8000	
ST509	8632	
124586	632	
125578	8000	

MS21059L08	Purchased	No		110	Each	3,788.000	23

MS21059L08

Nut

Location	Loc Qty	Loc Code
ST316	2420	
123100	7	
123900	13	
124307	400	24X124307
124555	400	
125654	1600	
st507	1368	
123265	400	
123352	68	
124093	400	
124291	400	
124308	100	9 1X124308

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
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Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592

102592

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield. LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

MS21059L3K	Purchased	No		110	Each	9.511.000	280

MS21059L3K

Nutplate

Location	Loc Qty	Loc Code
ST316	150	
124603	150	
st507	4500	
123603	1500	
124586	3000	
ST510a	3361	
123346	361	
124291	3000	
ST511	1500	
124093	1500	

MS21061L08	Purchased	No		110	Each	660.0000	50

MS21061L08

Nutplate

Location	Loc Qty	Loc Code
ST316	500	
125574	500	
st507	160	
125445	160	

MS21075L08	Purchased	No		110	Each	114.0000	5

MS21075L08

ANCHOR NUT

Location	Loc Qty	Loc Code
GA	7	
120560	7	
ST318	107	
103053	55	
124561	52	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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Landing Gear

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Picklist Print

June-04-13 10:24:59 AM

Work Order ID: 102592

102592

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Required Date:** 6/21/13

Start Qty: 5.00 **Required Qty:** 5.00

MS27039-08-10	Purchased	No	110	Each	3.962.000	22

MS27039-08-10

Screw

Location	Loc Qty	Loc Code
Mezz	6	
5865	6	
ST307	2203	
123100	1121	
123265	282	
123603	400	123603
124555	400	
ST308	1353	
123100	1353	
ST508	400	
124093	400	

NAS1149DN832J	Purchased	No	110	Each	2.577.000	22

NAS1149DN832J

WASHER

Location	Loc Qty	Loc Code
ST293	2405	
123348	60	
123352	200	15X 123352
123603	400	
123900	2	
124555	400	
125268	1343	
ST509	172	
124093	172	95X 124093

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 102592

June-04-13 10:24:54 AM

102592

Item ID: D206-817-011 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Screw-In Windshield, LH/RH

Start Date: 6/04/13 **Start Qty:** 5.00 *5*

Required Date: 6/21/13 **Req'd Qty:** 5.00 *5*

Reference: **Cust Item ID:**

Customer:

Approvals: **Process Plan:** MLS **Date:** 13-06-04 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
HN-D206-817	D								
100	DOCUMENT CONTROL	0.00					MO	130626	
100									
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-817-011 CHG003 ~~CHG003~~ ooy see attachment								
110	Pick Kit	0.00							
110									
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	**Memo**	0.00							
Quality Control									

Change Record

Part Number: D206-817-011

Description: SCREW-IN WINDSHIELD, LH/RH

CHG #	DATE	BY	RELEVANT DOCUMENTS	ECN #
001	12.02.14	KJ	IIN-D206-817 REV B, ICA-D206-817 REV 0	12-524
002	12.06.06	KJ	IIN-D206-817 REV C, ICA-D206-817 REV 1	12-602
003	13.04.22	KJ	IIN-D206-817 REV D, ICA-D206-817 REV 2, DSI 9643 REV B	13-554
			D4541, D4542 REV D, D4543 REV B	
004	13.06.25	KJ	DSI 9659 REV A	13-583